

Date: Tuesday, 9/19/2006 2:11:39 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CROSSBOLT SPACER
Job Number	: 28648		
Estimate Number	: 11010		
P.O. Number	: <i>N/A</i>	Part Number	: D2649
This Issue	: 9/19/2006 S.O. No. : <i>N/A</i>	Drawing Number	: D2649 REV B1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : MACHINED PARTS	Drawing Revision	: B1
Previous Run	: 28250	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 9/30/2006 Qty: 400 Um: Each
Checked & Approved By	: <i>[Signature]</i> 06 09.19		
Comment	: Est F 02.03.26 Added turning on Cobra NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T0375W058	6061-T6 Tube .375 x.058W
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Comment: Qty.: 0.2975 f(s)/Unit Total : 118.9860 f(s)
 6061-T6 Tube .375 x.058W

Material: 6061-T6 or 5052-H32, 0.375" Dia X 0.058" Wall

Batch

201937

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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PG*Issue P.O. 2080**cold 09/19**(400)*

Comment: HARDINGE CNC LATHE SMALL

Machine as per folio on cobra machine.

turn per drawing D2649 Rev.B1

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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RG*Receive + Inspect*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

for transit damage Bedda for 420

4.0	QC5	SECOND CHECK
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Comment: SECOND CHECK

*Inspect Levels Job 10-10**counted (417)*

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *S154**LB 06/10/10**(417)*

6.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

*PD 06/10/11**(417)*

Job Completion

*W 06-10-11*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/10/14

QA: N/C Closed: _____ Date: _____

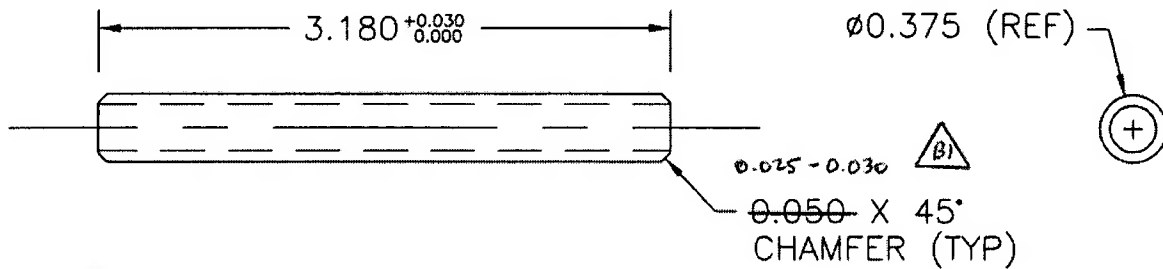
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>DM</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DM</i>	APPROVED <i>BW</i>	DRAWING NO. D2649	REV. B SHEET 1 OF 1
DATE 98.01.14		TITLE CROSS BOLT SPACER	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	98.01.14	3.180 WAS 3.230, ADD CHAMFER	
B1	# <i>CP</i> 02.06.13	REDUCE CHAMFER PER TSR 1296.	

RELEASED
98.01.20 DS



MATERIAL: 6061-T6 (WW-T-700/6) OR 5052-H32 (WW-T-700/4)
0.375 DIA 0.058 WALL

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

THIS COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 28648



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>MATERIAL BATCH NUMBER</u>	<u>P.O. NUMBER</u>
417 ✓	D2649	Cross Bolt Spacer	M101937	2080
133	D3503	Cross Bolt Spacer	M304R100 M18429	2080

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi (Regula) Walz

Vankleek Hill, October 5, 2006